

**Work Order ID 59105**

Wednesday, May 26, 2010 12:40:48 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

10-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				1	—	—	Aw 4 10-531
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

① 0 BE 10/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M112860

BE 10/06/01

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M112860

BE 10/06/01

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

M 10/06/02

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

10-6-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8.10.06.03

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.06.03

10 06 15 ①

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Stop**

**Insp.  
Stamp**

0.00

1 2 3 4 5 6 7 8 9 10 11 12

M 114841

## Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45  
3200  
8:15

① bk 10-6-16.

0.00

[illegible]

## Memo

0.00

QC

## Quality Control

$\Rightarrow 10101011$

1 0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

10/06/16 1 0/

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M113549

Sikaflex expire date: 10/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M113549

Sikaflex expire date: 10/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 11114432

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location:								
	PPP Rev: <u>PPP 59003</u>								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

4010/06/1710/06/17MP  
10-6-17

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, May 26, 2010 12:40:52 PM

Page 1

Work Order ID: 59105

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 5/26/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1

Manufactured No

110 Each

11.0000

1

1



205 Skidtube bent detail

Location

Loc Qty

Loc Code

LG

7

57028

1

58384

1

58385

1

58618

2

58619

2

ST046

4

58747

2

58748

2

*Handwritten:* 10-5-31 (7)

D2576-3

Manufactured No

140 Each

99.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

99

46661

51

52215

48

*Handwritten:* 1 BE 10/06/01

D2579

Manufactured No

140 Each

224.0000

20

20



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

224

57052

5

57348

8

58433

211

*Handwritten:* 20 BE 10/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 5/26/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

97.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

2

56613

2

ST026

95

50513

1

50770

28

51539

13

53791

53

X1 M 10/06/16

AN3-5A

Purchased

No

200

Each

943.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

943

105057

943

X2 M 10/06/16

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

3,937.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3937

110985

3937

X2 M 10/06/16

ALS7-1032-130

Purchased

No

200

Each

17.0000

50

50



Insert

Location

Loc Qty

Loc Code

ST282

17

113238

17

11014654

X50 M 10/06/16

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 5/26/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	200	Each	1,139.000	50	50
							
BOLT							

Location

Loc Qty

Loc Code

ST350

1139

M114859

x 50 H 10/06/16

114103

501

114108

300

114416

12

114523

326

AN960C10L

NAS1149C0332  
R

Purchased

No

200

Each

0.0000

50

50



M114341

washer

x 50 H 10/06/16

D3566-13

Manufactured

No

200

Each

25.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

25

53461

25

x 1 H 10/06/16

D3566-5

Manufactured

No

200

Each

13.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP015

13

57682

13

x 1 H 10/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1	Manufactured	No	200	Each	25.0000	2	2
							
Gasket							

Location	Loc Qty	Loc Code
----------	---------	----------

FP015


25

57715

4

8182

21

D3564-11	Manufactured	No	200	Each	1.0000	1	1
							
Wearshoe							

Location	Loc Qty	Loc Code
----------	---------	----------


FP019

1

57957

1

13 59021

D3564-13	Manufactured	No	200	Each	19.0000	1	1
							
Wearshoe							

Location	Loc Qty	Loc Code
----------	---------	----------

FP17


19

57684

5

57922

14

D3564-9	Manufactured	No	200	Each	14.0000	1	1
							
Wearshoe							

Location	Loc Qty	Loc Code
----------	---------	----------

FP

1

55334

1

FP019

13

57958

13

W/O:		WORK ORDER CHANGES					
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Start Date: 5/26/2010

Required Date: 5/31/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 21.0000 1 1  
 Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	20	
57525	1	
58709	19	

D2594-3 Manufactured No 200 Each 279.0000 16 16  
 O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	279	
55546	19	
58191	260	

D2594-1 Manufactured No 200 Each 454.0000 16 16  
 Plug, 205 Skidtube

Location	Loc Qty	Loc Code
FP	302	
42807	112	
55002	71	
57826	119	
FP14	152	
58434	152	

W/O:		WORK ORDER CHANGES					
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**DART****RELEASED**  
07.06.28 #

DESIGN #	DRAWN BY RH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59105  
8810-5-26

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

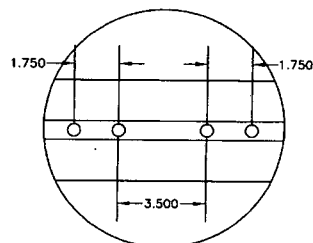
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

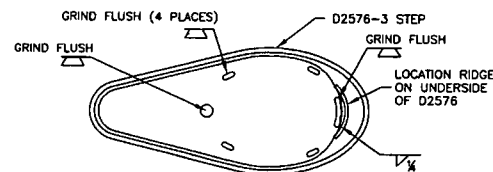
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DETAIL A**  
SCALE 5:24

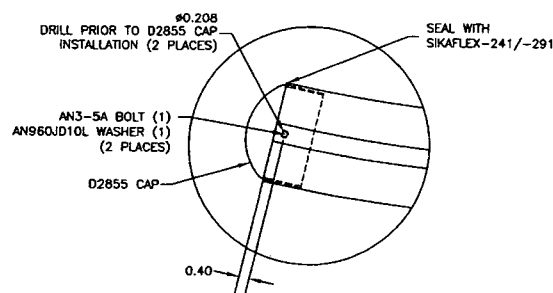


**DETAIL B**  
SCALE 5:24

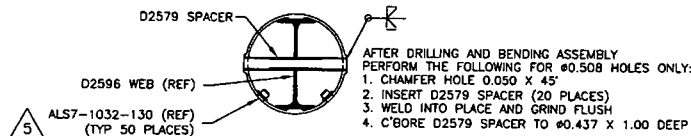


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07 de 28

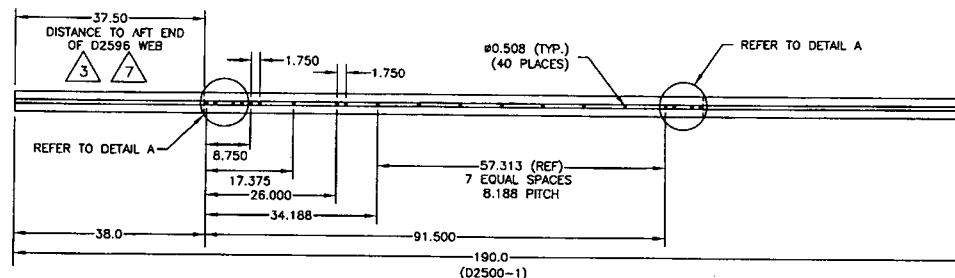
**DETAIL C**  
SCALE 5:24



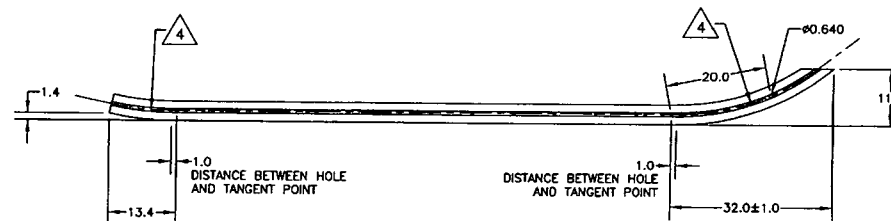
**SECTION D-D**  
SCALE 5:24



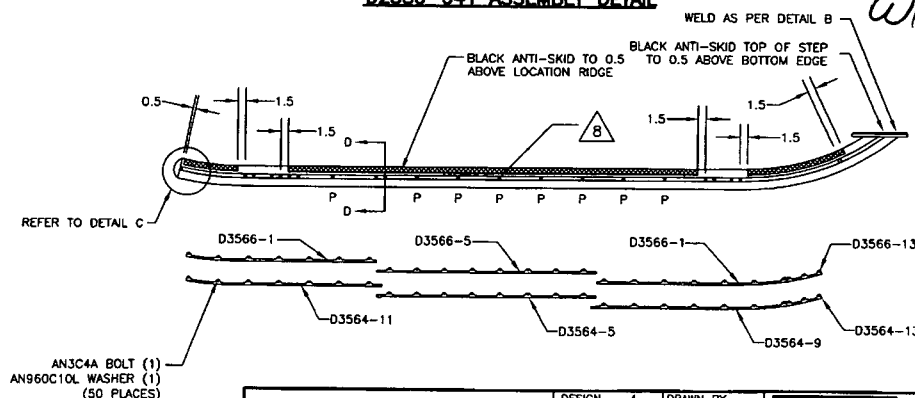
**D2580-1 DRILLING DETAIL**



**D2580-1 BENDING AND CUTTING DETAIL**



**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DRAWN BY *PH*

CHECKED *H*

APPROVED *H*

DATE 07.02.27

**DART**

**DART AEROSPACE LTD.**  
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.

D2580

TITLE

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 2 OF 3

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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07 Dec 28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

Diagram illustrating the assembly of a circular component, likely a cap or cover, showing the following components and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Indicated by a dashed line and arrows pointing to two locations on the cap.
- SEAL WITH SIKAFLEX-241/-291**: Indicated by a line pointing to the sealant application area.
- AN3-SA BOLT (1)**: One bolt is shown securing the cap.
- AN960UD10L WASHER (1)**: One washer is shown under the bolt.
- D2855 CAP**: The main component being installed.
- SEE NOTE ii)**: Reference to a note regarding the assembly.
- 0.40**: Dimension indicating the thickness of the component.

Diagram of a circular component with labels:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)
- AFTER PERFO.
  1. CHA
  2. INS
  3. WE
  4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

Ø0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500

190.0  
(D2500-1)

Profile view of the bridge deck showing dimensions and callouts:

- 5.985
- 1.4
- 51.340
- 5.338 (REF)
- 39.580
- 5.915
- 90.508 (8 PLACES)
- 3.630 (REF)
- 20.0
- 90.640
- 11.0
- 1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT
- 13.4
- 1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT
- 32.0 ± 1.0

**WELD AS PER DETAIL F**

**BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE**

**BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE**

**NO C'BORE NO PLUG**

**REFER TO DETAIL G**

**NO C'BORE NO PLUG**

**D3566-1**

**D3566-5**

**D3566-1**

**D3566-13**

**D3564-11**

**D3564-5**

**D3564-9**

**D3564-13**

**AN3C4A BOLT (1)**

**AN960C10L WASHER (1)**


**(50 PLACES)**

**8**

**P P P P P P P P**

**H H**

**0.5 1.5 1.5 1.5 1.5 1.5 1.5 1.5**

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	CHECKED	APPROVED		DRAWING NO.	REV. D
				02580	SHEET 3 OF 3
	DATE			TITLE	SCALE
	07.02.27			205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

NO. 232

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 59805  
Part number: D205-634-041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Duml. Date of Test Coupon 10.06.01  
Welder Barclay Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld